

Date: Wednesday, 6/6/2007 1:58:39 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT PLATE ASSEMBLY
Job Number	: 32802		
Estimate Number	: 11053		
P.O. Number	: <u>N/A</u>	Part Number	: D2873043
This Issue	: 6/6/2007	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D2873 REVA
First Issue	: <u>N/A</u>	Project Number	: N/A
Previous Run	: 32512	Drawing Revision	: <u>A</u>
	Type : MACHINED PARTS	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 6/30/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	30 Um: Each
Comment	: Est A 05.09.13 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0375X01000	6061T6 BAR
-----	--------------------	------------



Comment: Qty.: 0.3237 f(s)/Unit Total : 9.7115 f(s)
 6061T6 BAR
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8)
 (M6061T6B0.375x01.000)
 Identify for D2873-3
 Batch: 104598

BC 07-06-29 30

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks: 1.000" x 0.375" x 3.700" long

BC 07-06-29 30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA and Dwg D2873
 Identify as D2873-3 Dwg Rev A Folio Rev AA

BC 07-06-29 30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BC 07-06-29 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:58:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 32802

Part Number: D2873043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 07/06/29

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2- C'sink as per Dwg D2873

SAD 07/07/06

(30)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/06

counted

(430)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MS

070706

(30)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION

MF 07-07-10

10.0

MS20426AD46

Rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 180.0000 Each(s)

Rivet

Pick;

Qty

Part Number

Description

Batch

6

MS20426AD4-6

Rivet

m2566 x155mx

m100151

x25mx

11.0

MS21075L5

Nut Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 90.0000 Each(s)

Nut Plate

Pick;

Qty

Part Number

Description

Batch

3

MS21075L5

Nut Plate

m18136 -

MF

07-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 11/07/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:58:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 32802

Part Number: D2873043

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

mf 07-07-10

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/10

counted
(30)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Ep 07/07/10 (30)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/11

Job Completion



u 07-07-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 32802
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1

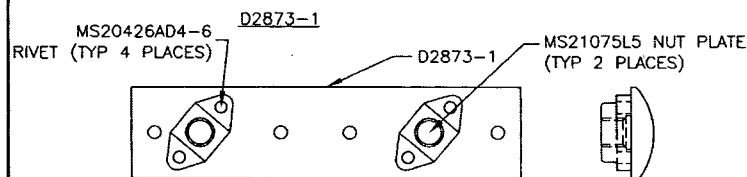
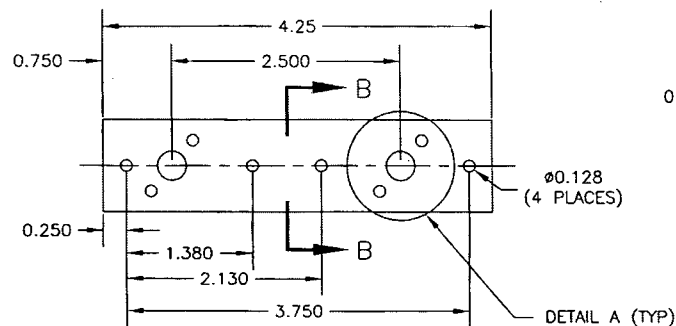
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

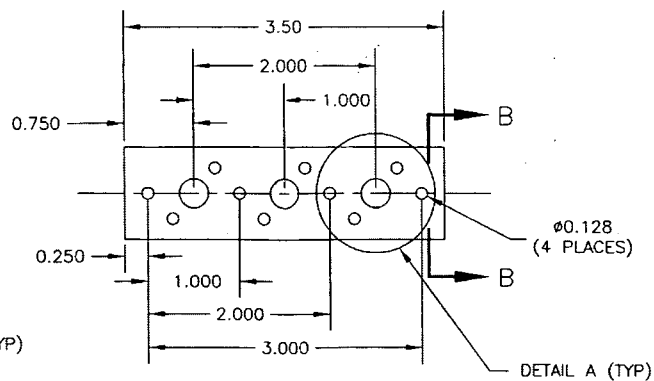
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.502	✓			
2.000	+/-0.010	2.000	✓			
0.750	+/-0.010	.750	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.250	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	.130	✓			
0.359	+/-0.010	.360	✓			
Ø0.316	+0.006/-0.001	.318	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.252	✓			
0.061	+/-0.010	.061	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.230 x .127	✓			

Measured by: 36	Audited by: JML	Prototype Approval:	N/A
Date: 07.06.29	Date: 07/06/29	Date:	N/A

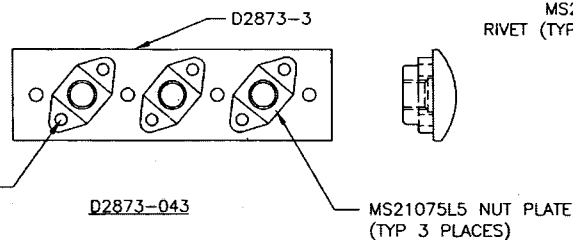
Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	



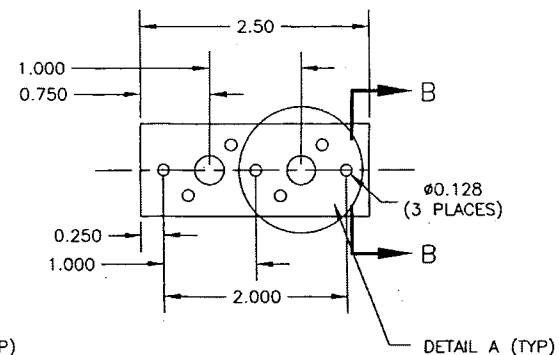
D2873-041



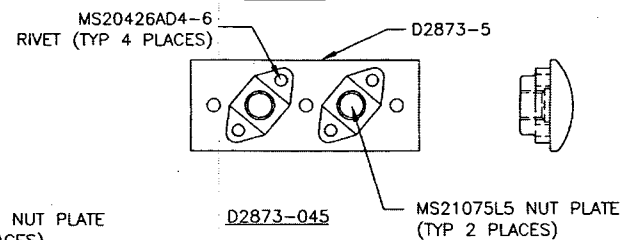
D2873-3



D2873-043



D2873-5



D2873-045

D2873-1/-3/-5 RADIUS BLOCK

- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\phi 0.128$ PILOT + C'BORE CURVED SIDE $\phi 0.230 \times 0.125$ DEEP + C'SINK CURVED SIDE $\phi 0.225 \times 100'$

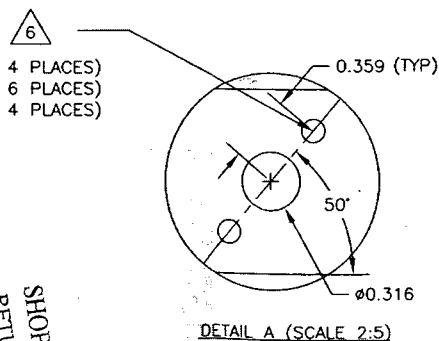
D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

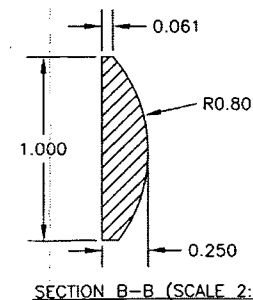
D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE

(-041 4 PLACES)
(-043 6 PLACES)
(-045 4 PLACES)



DETAIL A (SCALE 2:5)



RELEASED
05-07-26

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD HAMPSHIRE, ENGLAND, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26		TITLE RADIUS BLOCK
		REV. A SHEET 1 OF 1 SCALE 4:5